



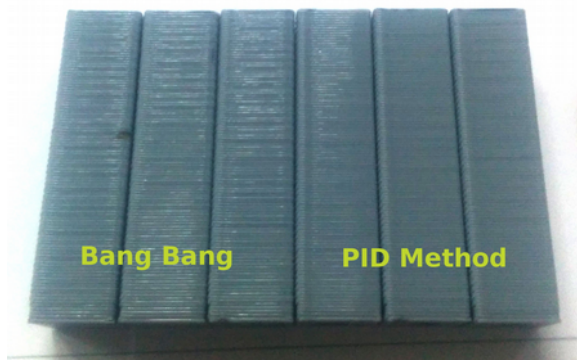
Service Bulletin

Affected product:	LulzBot TAZ 6 , LulzBot Mini 3D printer
LulzBot TAZ 6:	Serial KT-PR0041(NA, EU, AU)-15000>23454
LulzBot Mini:	Serial KT-PR0035(NA, EU, AU)-00050>07499
Effective date:	August 21, 2017
Service issue:	A firmware update has been implemented to correct a bug in the heated print surface temperature management method for improved printed object cosmetics.

Indication: Recently the LulzBot 3D Printer user community reported that some LulzBot TAZ 6 and LulzBot Mini 3D Printers display print artifacts that appear as inconsistent layer stacking along print walls and sides, sometimes referred to as Z-axis banding. Community comments on the report noted that the firmware factory-installed on the LulzBot TAZ 6 3D Printer used the “Bang Bang” heating method for the heated print surface, as opposed to the more consistent “PID” control method.

The Aleph Objects Research and Development team confirmed that in the LulzBot TAZ 6 and early LulzBot Mini 3D Printer firmware, PID heat bed control had been erroneously disabled.

The preferred PID temperature control method can be easily restored by applying a firmware update.



Note:

The effect to which print surface quality is impacted by the bed heating method varies by material, ambient temperature, print speed, and layer height.

Most users will see nominal improvements in the appearance of vertical walls.

Corrective Action:

Apply the updated firmware to LulzBot TAZ 6 or LulzBot Mini 3D Printers within the serial range.

1. Install Cura LulzBot Edition version **21.08** by following the instructions available at LulzBot.com/Cura.
2. Follow the instructions available at LulzBot.com/Firmware to install the default firmware for your LulzBot 3D Printer.
3. Restore your Extruder steps per unit (Esteps) by following the instructions available at LulzBot.com/Firmware.



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